

Rev Sh

Work Order ID 110611

110611

Page 1

Item ID: D3868-1

Revision ID:

Item Name: Spacer

Start Date: 1/07/14

Start Qty: 10.00

10

Required Date: 1/10/14

Req'd Qty: 10.00

10

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: WUF

Date: 14-01-07

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3868

A

100

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3868

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

0.00

10 0 Ac
14-01-07

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

10 0 Ac
14-01-07

DAS
27
9-89

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

14/1/8

10 0 Ac

January-07-14 10:29:48 AM

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[illegible]

January-07-14 10:29:48 AM

Page 3

Accept

Setup Start *NS1*

Stop *NS2*

10

Cust Item ID:**Start Qty:** 10.00

10

Customer:

Req'd Qty: 10.00

Reference:

Run Start *NR1*

Stop *NR2*

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

DAS
27

QC

Memo

0.00

9-89
14/1/9

Quality Control

Identify as per dwg & Stock Location:

0.00

Memo

Packaging

0.00

Packaging

DAS
32
9-89

QC21- Final Inspection - Work Order Release

0.00

Memo

OC

0.00

Quality Control

Picklist Print

January-07-14 10:29:53 AM

Page 1

Work Order ID: 110611

110611

Parent Item: D3868-1

D3868-1

Parent Item Name: Spacer

Start Date: 1/07/14

Required Date: 1/10/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 09-01-19 as per prelim issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.040

Purchased

No

sf

251.9500

1

M6061T6S 040

ok 14.01.07

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

251.95

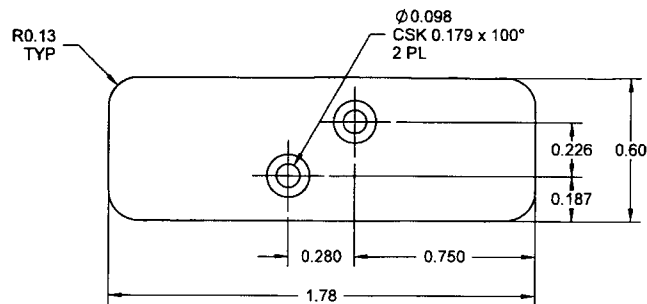
m126350

96

m126981

155.95

126981 → ①



D3868-1 SPACER

110611 MCLJ
14-01-07

RELEASED
09/01/13

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01 Lbs

A NEW ISSUE		BY	DATE
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.13		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	D3868	SHEET 1 OF 3
TITLE	SPACER	SCALE
		NTS

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R0.13
TYP

Ø0.098
CSK 0.179 x 100°
2 PL

0.226
0.60
0.187

1.345 0.750

2.85







0.04
REF

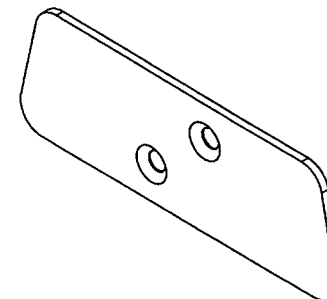
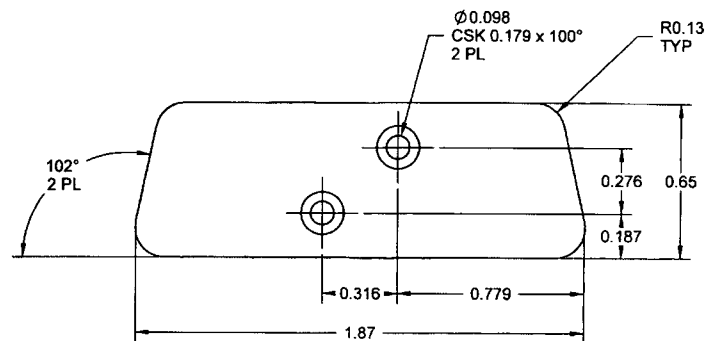
D3868-3 SPACER

RELEASED
09/01/13

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

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DE APPR.		SPACER	NTS
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D3868-5 SPACER

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NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01 Lbs

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